

Date: Monday, 06/11/2006 9:20:02 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D412-664-203
 Job Number : 29271
 Estimate Number : 10804
 P.O. Number : N/A Part Number : D412664203
 This Issue : 06/11/2006 S.O. No. : N/A Drawing Number : NCR 095
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : N/A
 Previous Run : 29190 Material : N/A
 Due Date : 13/11/2006 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment :

Additional Product

Job Number:



PN	D412-664-203	CHG	CHG003
DESC	Crosstube Aft High	SIC	SH01-9
LOT	B27084	SIC	SR01298NY
MODEL	Bell 412	SIC	

Seq. #: Machine Or Operation:

Description:

1.0

PACKAGING 1

PACKAGING RESOURCE 1



Comment: PACKAGING RESOURCE #1
 REMOVE FROM STOCK
 D412-664-203
 RECORD B/N'S

B27084

06.10.27

2.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1
 REMOVE SUPPORT D2896-1
 FROM CROSSTUBES AND LABEL SUPPORT
 WITH B/N OF CROSSTUBE IT CAME OFF OF

06-11-01 ①

3.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1
 REMOVE CENTRE ABRASION STRIP
 AND CLEAN OFF ALL ADHESIVE RESIDUE

06-11-01 ①

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Part Number: D412664203

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18 06-11-01 ①

5.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING
RE-PAINT SECTION OF CROSSTUBE
BETWEEN THE TWO CHAFING SHIELDS
AS PER QSI 005

MA 06 11 23

①

6.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

18 06-11-30 ①

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1
INSTALL SUPPORT D2896-1
USING MAGNOBOND 6398 B M 10 2437
ENSURING B/N MATCHES CROSSTUBE
AS PER DSI 9357
REPLACE CLAMPS
2 X MS21920-30 B M 10 1506
ADD RUBBER CUSHION
2 X D2182B (D2182B058) B 28042

18 06-11-30 ①

8.0

MS2192030

clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
clamp(per MIL-DTL-8783C)

↑

9.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 0.9600 f(s)/Unit Total : 0.9600 f(s)
Neoprene Cushion-.750 bl

↑

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Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/30 ①

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06/11/30 ①

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE PER PPP

ReVE RD 06/12/20 ①

add 2 copy of DST 9357 to paper work

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/21 ①

Job Completion



06.12.21



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9357	REV. A SHEET 1 OF 2
DATE 06.10.25		TITLE CROSSTUBE SUPPORT CHANGE	SCALE NTS
A	06.10.25	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D212-664 Rev. C AND
INSTRUCTIONS FOR CONTINUOUS AIRWORTHINESS ICA-D212-664 Rev. 2
REF. CANADIAN STC: SH01-9
REF. FAA STC: SR01298NY

For D412-664-203 Aft Crosstubes at CHG 002 or later, the D2856-600-1087 Abrasion Strip has been removed, the center D2896-1 Support has been bonded onto the crosstubes using Magnobond 6398 and D2182B058 Rubber Cushions have been installed underneath the MS21920-30 Clamps. Amend Parts List of IIN-D212-664 Section 5 and ICA-D212-664 Section 32.8 as follows:

Remove:

Item	QTY -203	Part Number	Description
32	1	D2856-600-1087	ABRASION STRIP

Add:

Item	QTY -203	Part Number	Description
41	2	D2182B058	RUBBER CUSHION

To prevent the center support from shifting on D412-664-203 Crosstubes at CHG 001, the D2896-1 Support should be removed and re-installed as follows:

- 1) Follow section 32.1 of ICA-D212-664 for the removal of the crosstubes from the helicopter.
- 2) Remove the qty(2) MS21920-30 Clamps from the crosstube that fasten the D2896-1 Supports to the crosstube.
- 3) Remove the D2856-600-1087 Abrasion Strip from the crosstube per section 32.5 of ICA-D212-664.
- 4) Inspect the crosstube surface underneath the support for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection. Touch up finish per item 5.3.9 of 300 hour inspection.
- 5) Apply a 0.03" to 0.06" thick layer of Magnobond 6398 underneath D2896-1 Support and re-install the Support on the crosstube as shown in Figure 1. Use rocker beam assembly to properly align the D2896-1 Support. Ensure the Rocker Beam Assembly can move freely without any friction with other parts. Install a D2182B058 Rubber Cushion on each MS21920-30 Clamp. Position and secure the D2896-1 Support on the crosstube using MS21920-30 Clamps. Torque clamps 80-100 in-lb. Let the D412-664-203 Crosstube Assembly cure before re-installing the crosstube or the aircraft.
- 6) Re-install the D412-664-203 crosstube per section 32.2.5 through 32.2.9 of ICA-D212-664.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

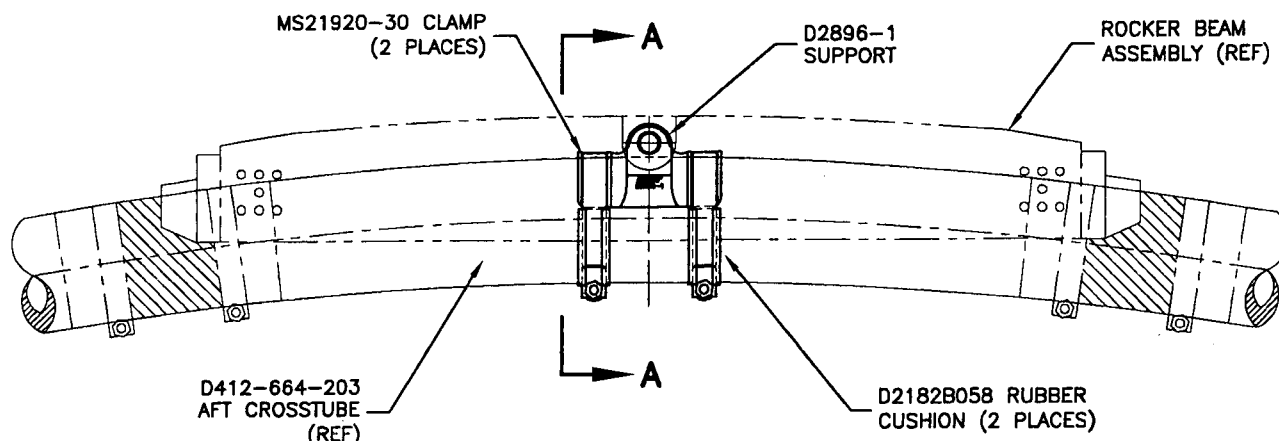
DATE: 06.10.25
CERT. NO.: SH01-9
ISSUE: 3

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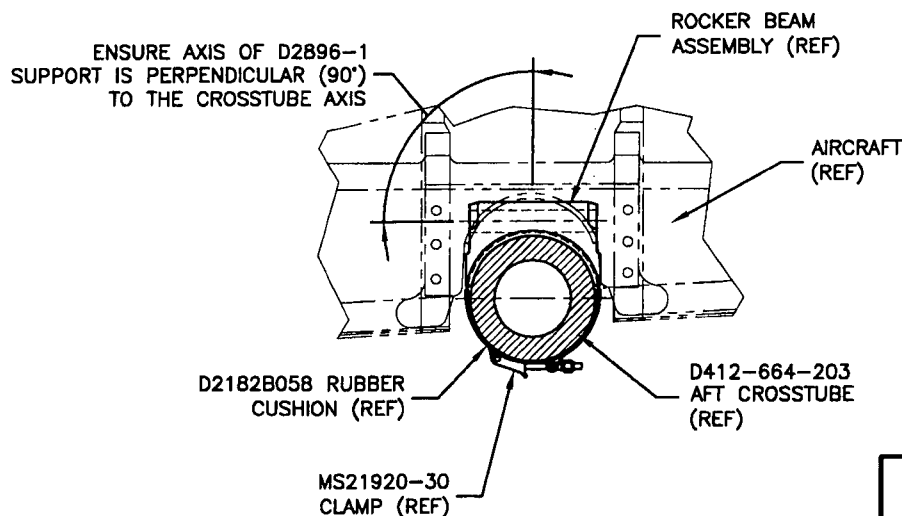
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9357	REV. A SHEET 2 OF 2
DATE 06.10.25		TITLE CROSSTUBE SUPPORT CHANGE	SCALE NTS



**FIGURE 1 - CROSSTUBE SUPPORT
INSTALLATION ON D412-664-203**



SECTION A-A
AIRCRAFT BODY SHOWN
AS REFERENCE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 06.10.25
CERT. NO.: SH01-9
ISSUE: 3

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